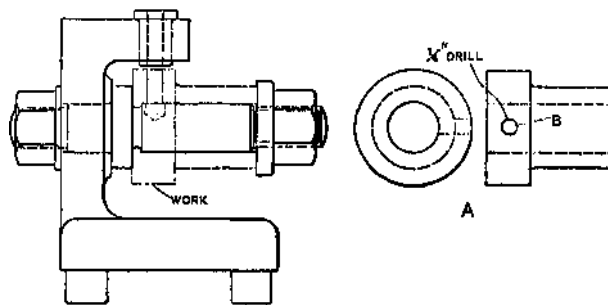


CHAPTER

SPECIAL JIG AND FIXTURE MECHANISMS

No single item influences the production rate to as great an extent as the design of jigs and fixtures. The saving of a few seconds clamping time means an increased production that offsets a high first cost. It is much easier for an operator to clamp his work by tightening one nut than the usual three, and, aside from the saving of time, he is expending less energy and works to better advantage to himself and his employer.

It is usually necessary to equalize the pressure in a jig before



Machinery

Fig. i. Simple way of Clamping a Bushing for Drilling

applying the clamping pressure. When equalizing and clamping mechanisms are both operated by a single clamping operation, the danger of clamping before equalizing the pressure can be eliminated. Many object to the term "fool-proof,"¹¹ but the amount of work spoiled or sprung by careless clamping justifies care in designing jigs and fixtures that are at least "error-proof" in this respect.

The mechanisms described in this chapter are selected for their suggestive value, and only as much of the fixture is shown as